



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4681-041
Job Sheet 180346



Part No: D4681-041

Job Qty: 4 ea

Part Name: Web Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 7/24/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2 IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB1 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/24/18	7/24/18	0.00	0.00	Start Up Skid tubes-2		JW
110	Skid tubes	4 pcs	7/24/18	7/24/18	0.00	3.45	Skid tubes-2		JW DAS
120	QC	4 pcs	7/24/18	7/24/18	0.00	0.00	QC6		JW 38
121	CNC Vertical Machining	4 pcs	7/24/18	7/24/18	0.18	2.63	HAAS1-5		JW 9-88
122	QC	4 pcs	7/24/18	7/24/18	0.00	0.00	QC2 Machining-3	SB2	JW 2018-07-16
123	QC	4 pcs	7/24/18	7/24/18	0.00	0.00	QC8 Machining-3		JW 2018-07-16 SBL
130	HandFinish	4 pcs	7/24/18	7/24/18	0.00	1.12	HandFinish1		JW 12/27/17
140	QC	4 pcs	7/24/18	7/24/18	0.00	0.00	QC7-4		JW
150	Skid tubes	4 pcs	7/24/18	7/24/18	0.00	3.45	Skid tubes-3		JW
160	QC	4 pcs	7/24/18	7/24/18	0.00	0.00	QC5		JW
170	Packaging	4 pcs	7/24/18	7/24/18	0.00	0.00	Packaging3-2		JW
180	QC21-SA	4 Ea	7/24/18	7/24/18	0.00	0.00	QC21		JW 2018-07-16

Part Op 110 - 1- CUT TO LENGHT AS PER DWG

Descriptions: 121 - MILL AS PER DWG AND FOLIO FB186 DWG REV: _____ FOLIO REV: _____ DEBURR
150 - INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R
PROSEAL: M138848 exp: 11/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	4 Ea (1 ea)	90-Start up Operation	BIS6872
D4681-3	Doubler	8 Ea (2 ea)	150-Skid tubes	SO 75469
MS20470AD4-6	Rivet, Universal Head	356 Ea (89 ea)	150-Skid tubes	SO 41165

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2963-125	4	104	0
150-Skid tubes	D4681-3	8	25	0
	MS20470AD4-6	356	2,661	0

Part Specifications

Specifications could not be found.

Plex 7/5/18 9:25 AM dart.white.jesse

DART
AEROSPACE

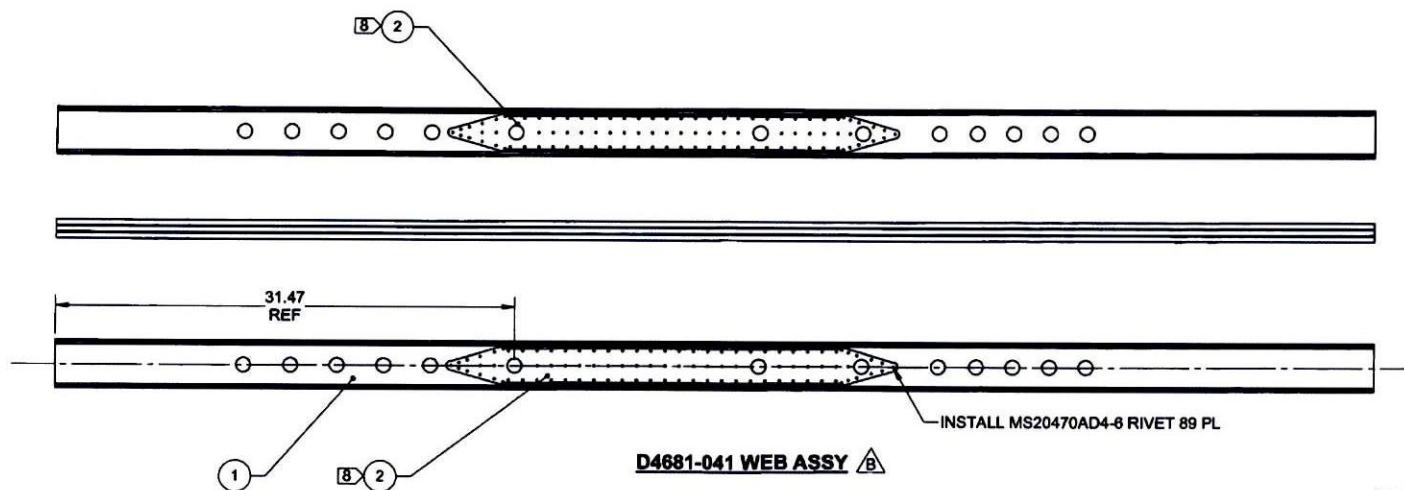
Container No: S091124

Part: D4681-041
Job No: 180346
Serial No/Batch: S091124
Revision: b
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/12/18

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4681-041	WEB ASSY
1	1	D4681-1	WEB
2	2	D4681-3	DOUBLER
3	89	MS20470AD4-6	RIVET, PAN HEAD

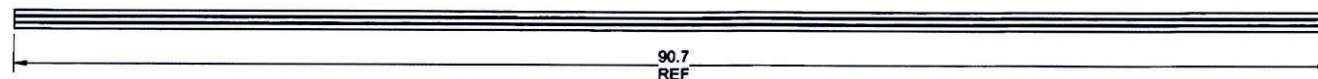
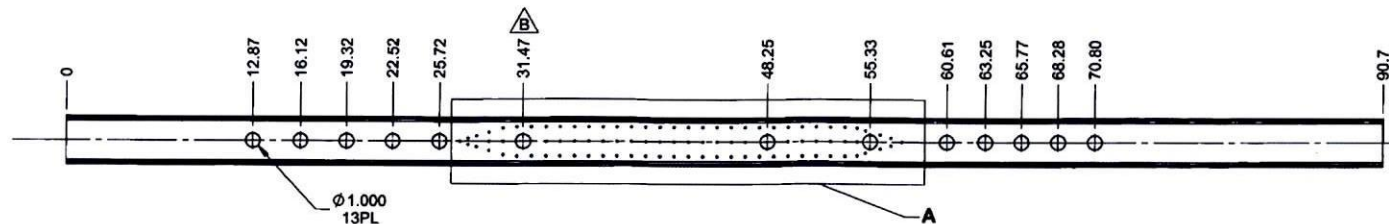


NOTES:

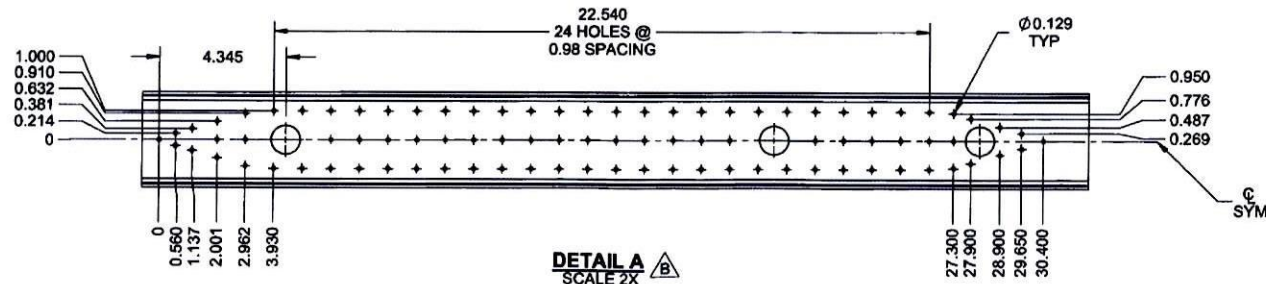
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4681-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 5.94 lbs
- 8) SEAL FAYING SURFACES WITH PROSEAL P/S 890 B-1/2 (PRC)

B	MS20470AD4-6 WAS MS20470AD4-7, ADDED DETAIL A ON SHEET 2, VARIOUS DIMENSIONAL CHANGES.	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	AS		
MFG. APPR.	2/		
APPROVED	2/		
DE APPR.	2/		
DATE	13.08.08		
DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4681 TITLE WEB ASSY REV. B SHEET 1 OF 4 SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

RELEASED
2013-11-13
WV



D4681-1 WEB



DETAIL A
SCALE 2X

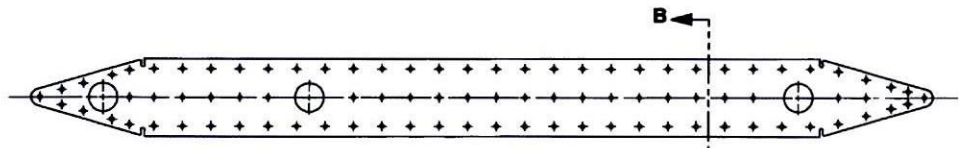
RELEASED
2013-11-13

NOTES:

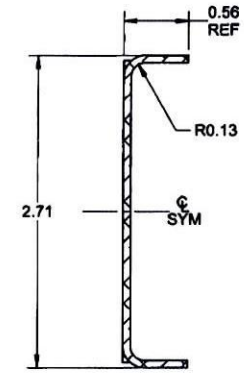
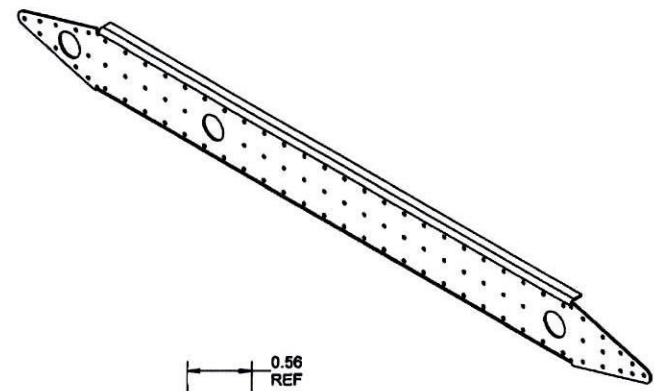
- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.74 lbs

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AP	D4681	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEB ASSY	NTS
DATE	13.08.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D4681-3 DOUBLER



SECTION B-B
SCALE 4X

RELEASED
2013-11-13
MP

- NOTES:**
- 1) MATERIAL: MAKE FROM D4681-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: .56 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D4681	SHEET 3 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEB ASSY	NTS
DATE	13.08.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

